

**Work Order ID 59956**

Monday, June 21, 2010 7:53:13 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 6/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-6-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3914

A

100

Weld per dwg A/R S.S. rod Batch: *4113328* 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A  
2- weld hinge (3) and Mounting brackets as per dwg D3914  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D3914  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

*SL 10/06/23*

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*QC 10-07-07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 59956

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Page 2

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Revision ID:

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Stop



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Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

810107107

10

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time: 1:20

Oven Temperature: 320°

Finish Time: 1:50

10-7-7.

140

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

10107107

1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

E50/07/08 ①

160

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

0.00

Packaging

E50/07/08 ②

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*100708*  
*MF*  
*10-7-8*

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 21, 2010 7:53:12 AM

Page 1 / 3

Work Order ID: 59956

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)




Start Date: 6/21/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581  Mounting Bracket		Manufactured	No			100	Each	41.0000	2	2			
<div> <div>Location</div> <div>ST</div> <div>59121</div> <div>WA</div> <div>46086</div> <div>51745</div> <div>57185</div> <div>59265</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>15</div> <div>26</div> <div>2</div> <div>2</div> <div>1</div> <div>21</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													
✓ D3914-1  Rib		Manufactured	No			100	Each	4.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>59295</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
✓ D3914-7  Rib		Manufactured	No			100	Each	4.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>59095</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B59121 (2) 10/06/22

10/06/22

(2) 10/06/22

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2 / 3

Work Order ID: 59956

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/21/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4016-3 Manufactured No 100 Each 13.0000 3 3  
Hinge Half, Lid

Location	Loc Qty	Loc Code
ST116	1	
58243	1	
WA	12	
58737	6	
59744	6	



SY 10/06/22

①

②

✓ D4018-5 Manufactured No 100 Each 21.0000 9 9  
Rib

Location	Loc Qty	Loc Code
WA	21	
58594	3	
58669	18	



SY 10/06/22

③

④

✓ D4020-5 Manufactured No 100 Each 1.0000 1 1  
Mesh (350 Basket Long, Lid)

Location	Loc Qty	Loc Code
WA	1	
59029	1	



SY 10/06/23

①

✓ D4021-3 Manufactured No 100 Each 4.0000 1 1  
Data Plate

Location	Loc Qty	Loc Code
WA	4	
56050	1	
59054	3	



SY 10/06/22

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, June 21, 2010 7:53:12 AM

Page 3

Work Order ID: 59956

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/21/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041	Manufactured	No	100	Each	0.0000	1	1	
Lid Rib Assembly, Fwd (350 Basket)								
✓ D4035-043	Manufactured	No	100	Each	2.0000	1	1	
Lid Rib Assembly, Aft (350 Basket)								
<div> <div>Location</div> <div>WA</div> <div>59415</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>								
D2728-3	Manufactured	No	140	Each	0.0000	1	1	
Dart Logo label								
D4086-210	Manufactured	No	140	Each	10.0000	1	1	
Placard, Max Load								
<div> <div>Location</div> <div>ST117</div> <div>58926</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>								

B359414 ① SS 10/06/22

B359415 ① SY 10/06/22

M115050 (H)

ES 10/07/08

ES 10/07/08

Monday, June 21, 2010 7:53:12 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

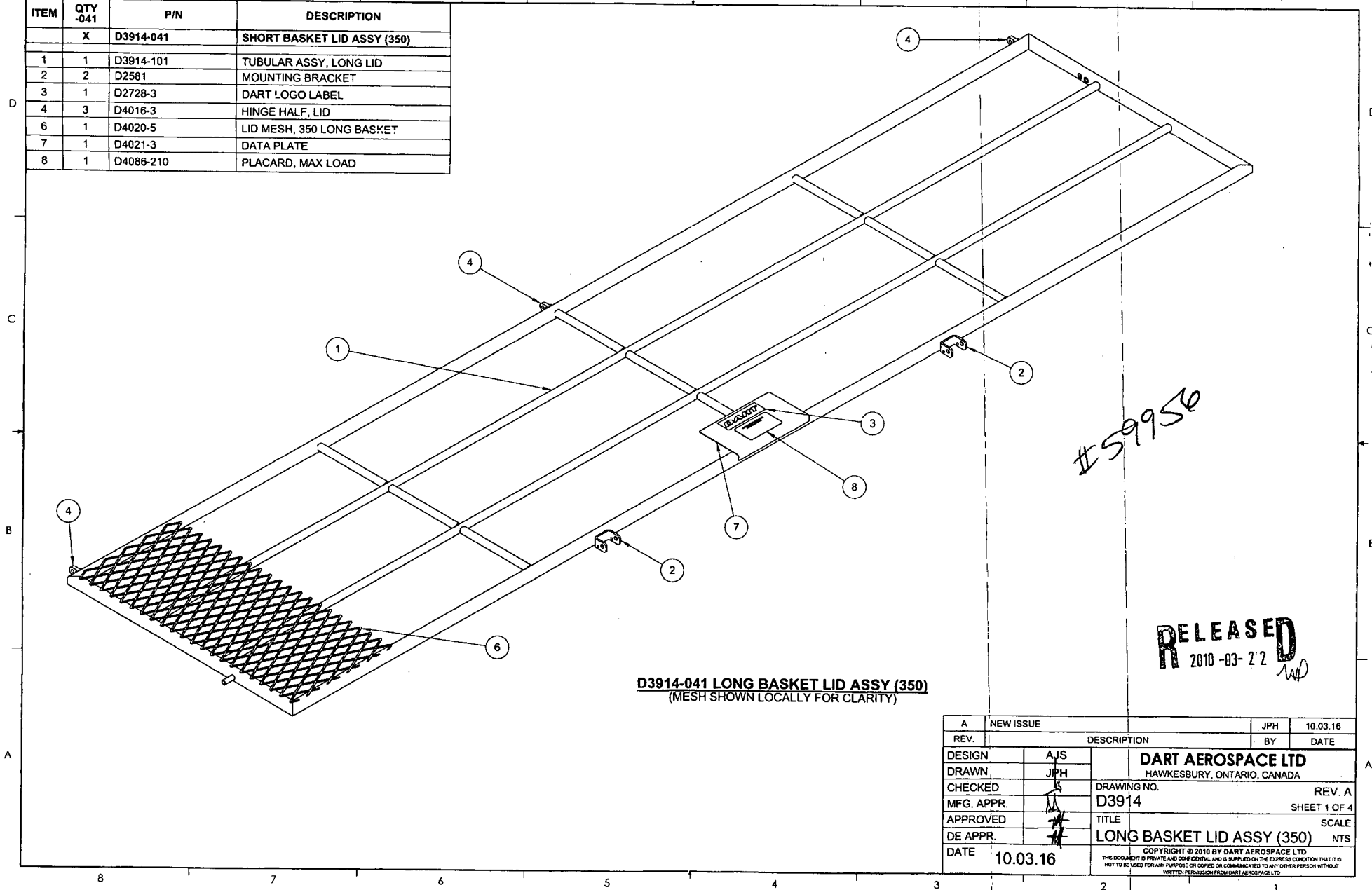
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-03-22

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3914	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Dart Aerospace Ltd**

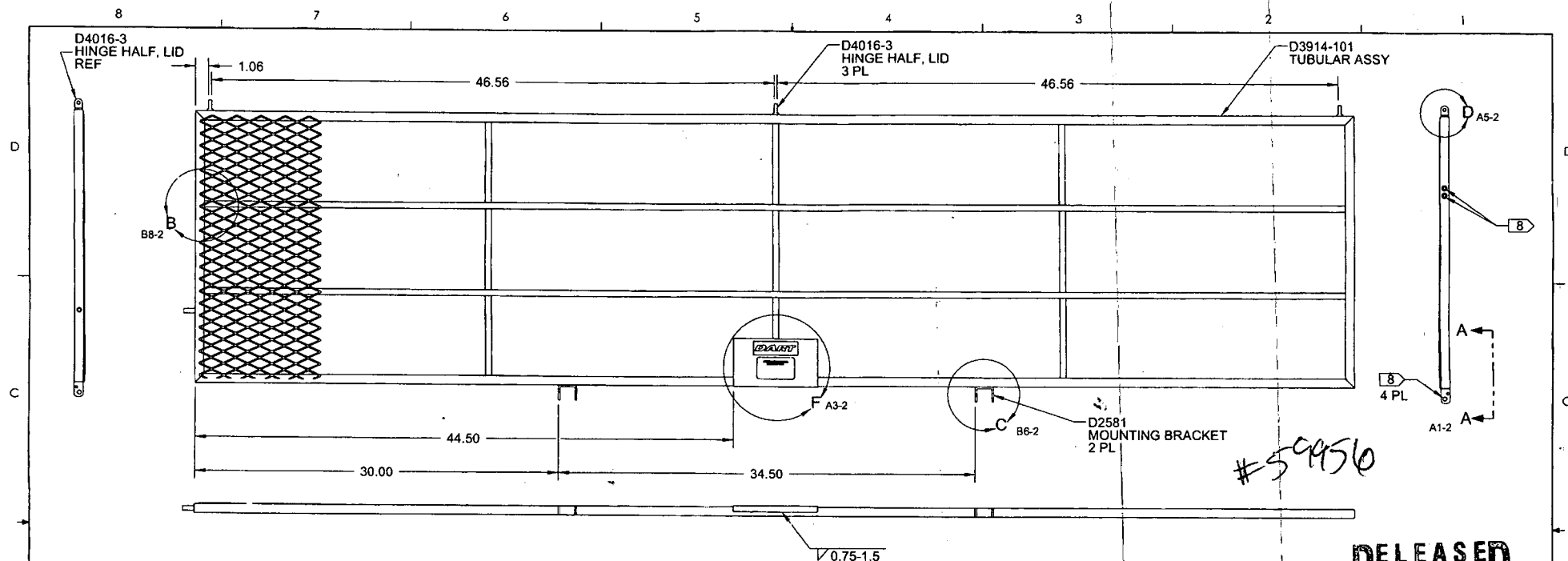
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

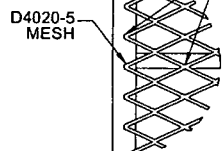
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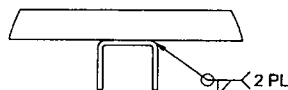


**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

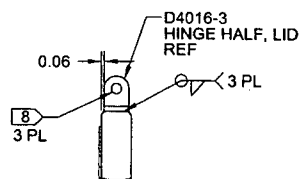
TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION



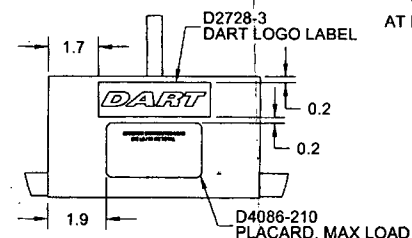
**DETAIL B** D8-2



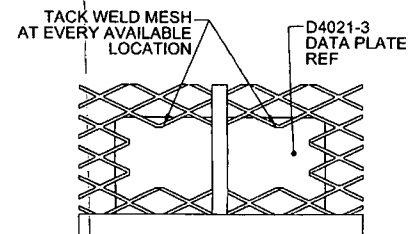
**DETAIL C** C3-2



**DETAIL D** D1-2



**DETAIL F** C4-2



**VIEW A-A** C1-2

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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**NOTE:** Date & initial all entries



ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

D

C

B

A

D4035-041  
RIB ASSY, FWD

TYP

D3914-1  
RIB  
2 PLD4018-5  
RIB  
9 PLD3914-7  
RIB  
2 PL

96.00

E c2-3

E

TYP

0.25

SECTION E-E C5-3

D4035-043  
RIB ASSY, AFT

22.50





6.67  
TYP23.25  
TYP

8 D3914-101 TUBULAR ASSY, LONG LID

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

RELEASED  
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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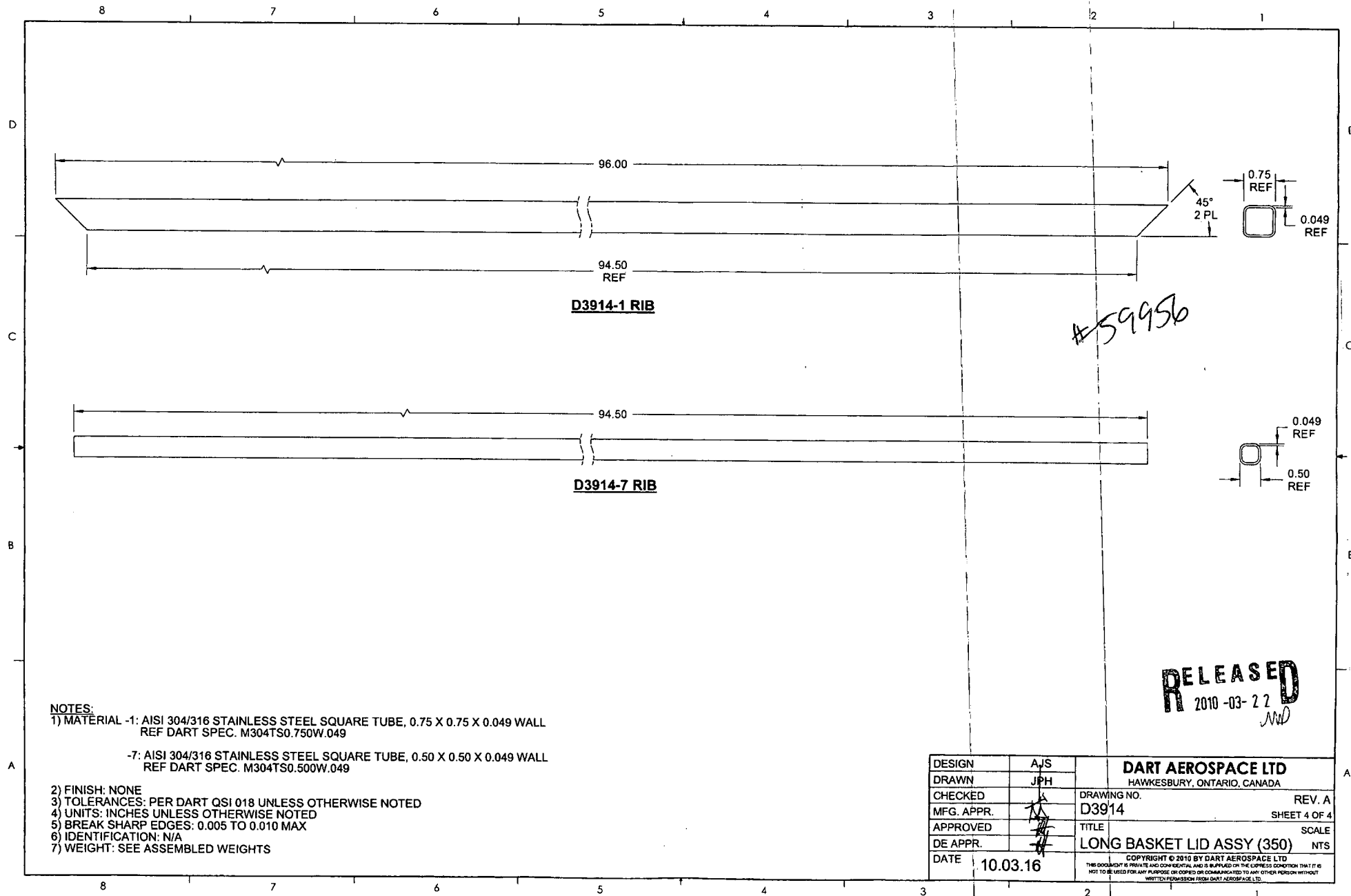
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